

Work Order ID 57254

March 31, 2010 10:28:10 AM



Page 1

Item ID: D2274

Accept

Revision ID:

Item Name: Radius Block

Start Date: 31/03/2010 Start Qty: 200.00

Required Date: 09/04/2010 Req'd Qty: 200.00

Reference:

Approvals: Process Plan: *PL*

Date: *10-3-31*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100



Shear

Shear

SHEAR

0.00

Memo

0.00

blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces

SL 10/04/05

215

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per folio D2274

0.00

0.00

SL 10/04/05

(215)

0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SL 10/04/05

215

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Setup Start



Item Name: Radius Block

Stop



Start Date: 31/03/2010 Start Qty: 200.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

mf 10/04/06

215

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Tumble ☐ Deburr any rough edges after tumbling

B 10-4-12

215

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

B 10-4-13

215

W/O:		WORK ORDER CHANGES					
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Item Name: Radius Block

Start Date: 31/03/2010 Start Qty: 200.00

Required Date: 09/04/2010 Req'd Qty: 200.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/04/13

215

170



Packaging

Packaging

Identify as per dwg & Stock Location: 016

0.00

Memo

0.00

10/4/13 215

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/14

UMF

10-4-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

March 31, 2010 10:28:14 AM

Page 1

Work Order ID: 57254

Parent Item: D2274

Parent Item Name: Radius Block

Comments: IPP H ☐ 00.05.18 ☐ Added inspection level 8 ☐ EC ☐

Start Date: 31/03/2010

Required Date: 09/04/2010

Start Qty: 200.00

Required Qty: 200.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased		No		100	f	209.9100	19.2842			



6061-T6 Bar .750 x .125



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT01

209.91

105061

3.4

109760

6.01

113608

80

113680

64

113719

56.5

19.4 SL 10/04/05

23

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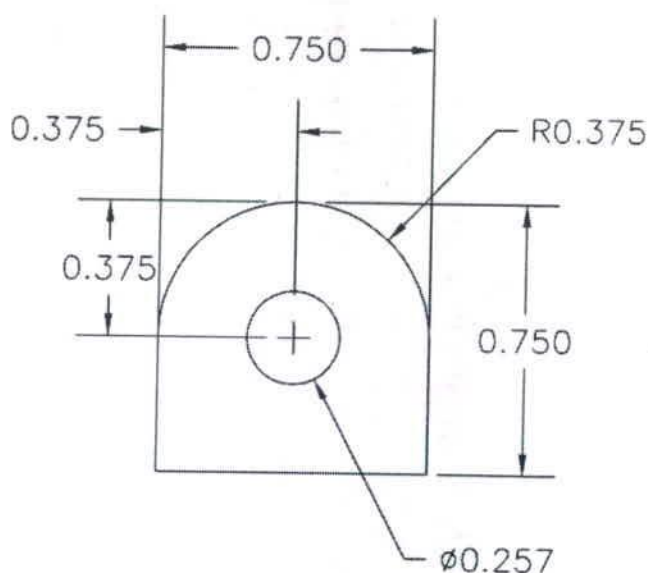
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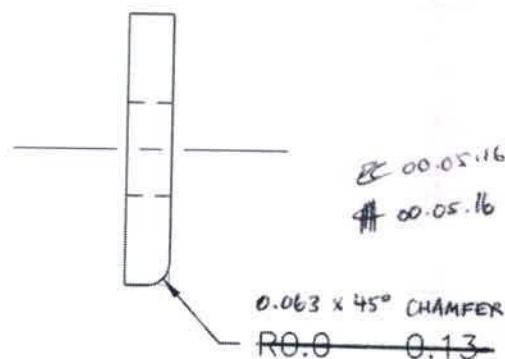
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57254

10-3-3



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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